

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000100**Date Inspected:** 17-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** N/A**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the welding qualification testing pertinent for the welding qualification record (PQR) HP200712-3 scheduled for this project. ZPMC, welder operator Zhan Xing Jin was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-223(2)1T-1 for the PQR identified as HP200712-3. Base metal was designated as A-709-50-2/Z25 (Heat # 06102938N) and appeared to meet the non fracture critical impact test requirement. The root opening of the joint was approximately 6 mm. ZPMC followed AWS 5.13 the production procedure WPS using the automatic submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter EH-14 electrode (Dual process PQR/FCAW and SAW). The QA Inspector verified amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspectors recorded welding parameters for a total of 6 passes. The QA inspectors observed that the welding parameters taken by ZPMC QA inspector Hu Gang appeared to be accurate and in accordance with the contract documents. ZPMC QC (CWI) Huang Wei witnessed the testing and performed visual weld inspections. The PQR HP200712-3 was completed on this date. The QA inspector issued the lot # B71-014-007 after completion.

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Summary of Conversations:

The QA inspector did not have any relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna, Alfredo

Quality Assurance Inspector

Reviewed By: McClary, David

QA Reviewer